

Work Order ID 73413

Wednesday, August 31, 2011 3:08:34 PM



Page 1

Item ID: D3278-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 8/31/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/08/31 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|-------|
| D3278 | Rev C |
|-------|-------|

100

0.00



SHEAR

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

ml 11/09/27

40 ✓

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA405 and Dwg D3278□2- Deburr and
Tumble□Identify as D3278-2

ml 11/09/30

40 ✓

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ml 11/09/30

40 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 73413

Wednesday, August 31, 2011 3:08:34 PM



Page 2

Item ID: D3278-2

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Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 8/31/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130 QC8- Inspect parts - second check

0.00

2L 11-09-30



QC Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish Memo

0.00

Hand Finishing

40 X Ø M-L 11/10/04

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat Memo

0.00

Powder Coating

START TIME: 9:15 ☐ OVEN TEMPERATURE: 320°F

FINISH TIME: 9:45

40 X Ø M-L 11/10/06

M118439

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 73413

Wednesday, August 31, 2011 3:08:34 PM



Page 3

Item ID: D3278-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 8/31/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

NO BK 11-10-6.

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

SB 11/10/06 40

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11 ME 11-10-07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 3:08:32 PM

Page 1

Work Order ID: 73413



Parent Item: D3278-2



Parent Item Name: Support

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: ☐A☐04.04.19☐New issue☐KJ/JLM☐

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B1.000X02.00 0 | | Purchased | No | | | 100 | f | 47.0890 | 0.2337 | 9.84 | | | |



6061-T6 Bar 1.00 x 2.00



| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT004 | 47.089 | |
| 112567 | 22.6 | |
| 116623 | 3.36 | |
| 118106 | 21.129 | |

M119007 x 9.84

mk 11/09/27

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector | |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
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NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 73413 |
| Description: Support | | Part Number: | D3278-2 |
| Inspection Dwg: D3278 Rev: C | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | Ø.098 | — | | Vern MI-06 | |
| 0.359 | +/-0.005 | .359 | — | | " | |
| 0.609 | +/-0.010 | .610 | — | | " | |
| 0.250 | +/-0.010 | .250 | — | | " | |
| 1.480 | +/-0.005 | 1.480 | — | | " | |
| R0.125 | +/-0.010 | R.125 | — | | R-6 | |
| 0.119 | +0.005/-0.004 | .120 | — | | " | |
| 2.439 | +/-0.010 | 2.440 | — | | " | |
| | | | | | " | |
| 1.980 | +/-0.010 | 1.980 | — | | " | |
| R0.13 | +/-0.030 | R.125 | — | | R-6 | |
| Ø0.257 | +0.005/-0.000 | Ø.258 | — | | " | |
| R0.375 | +/-0.010 | R.375 | — | | R-6 | |
| 0.875 | +/-0.010 | .875 | — | | " | |
| 0.500 | +/-0.010 | .500 | — | | " | |
| R0.400 | +/-0.010 | R.400 | — | | R-6 | |
| R1.00 | +/-0.030 | R1.00 | — | | R-6 | |
| | | | | | | |
| 1.720 | +/-0.010 | 1.720 | — | | " | |
| R0.125 | +/-0.010 | R.125 | — | | R-6 | |
| 0.125 | +/-0.010 | .126 | — | | " | |
| | | | | | | |

| | | | | | |
|---------------------|--------------------|--------------------|--------------------|----------------------------|-----|
| Measured by: | <i>[Signature]</i> | Audited by: | <i>[Signature]</i> | Prototype Approval: | N/A |
| Date: | 11/09/30 | Date: | 11-09-30 | Date: | N/A |

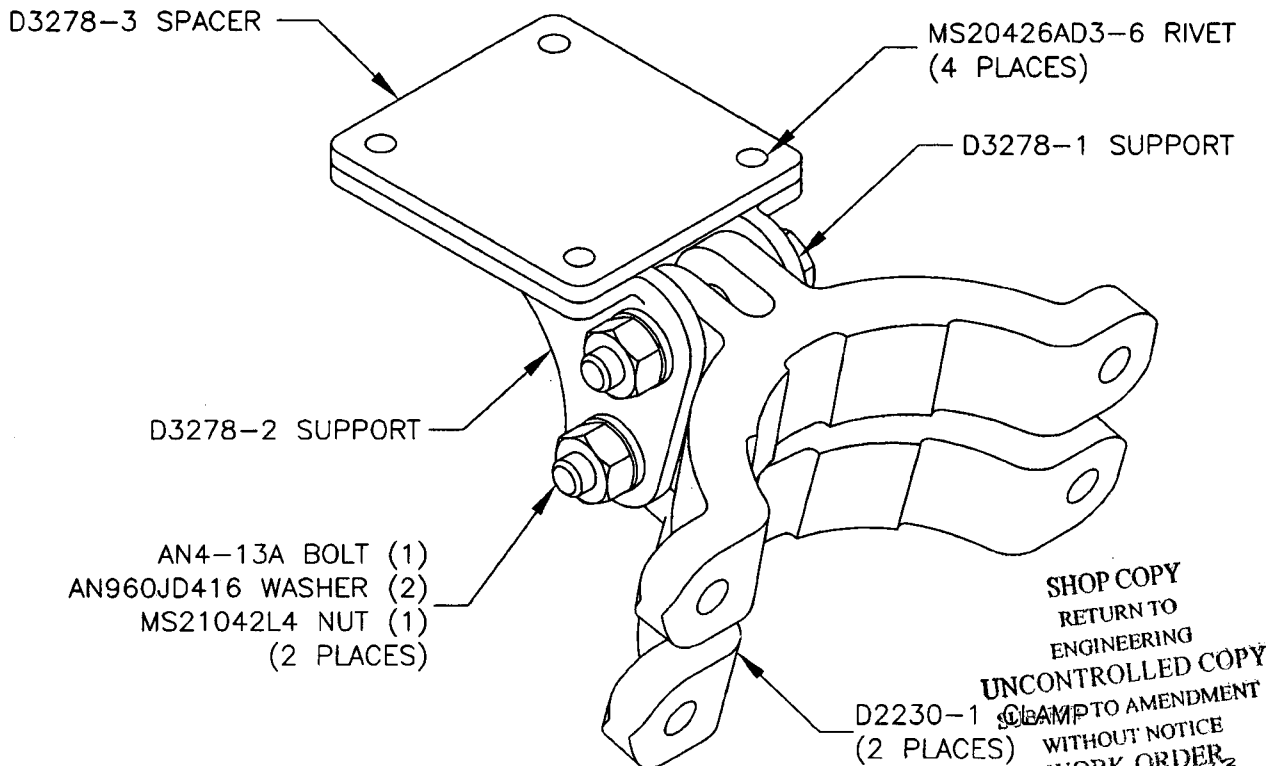
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|--------------------------|--------------------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM | |
| C | 07.09.26 | Dimensions updated per Dwg Rev. C | KJ/EC <i>[Signature]</i> | <i>[Signature]</i> |

DART

| | | | |
|------------------|-----------------|---|------------------------|
| DESIGN 97 | DRAWN BY B/C | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED B | APPROVED H | DRAWING NO. D3278 | REV. C SHEET 1 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE NTS |
| A | 04.03.03 | NEW ISSUE | |
| B | 05.03.31 | CHANGE DIM/TOL TO ENSURE FIT | |
| C | 07.07.24 | CHANGED RIVETS PER PAR #185 | |

RELEASED
07-08-18

D3278-041 SUPPORT ASSEMBLY



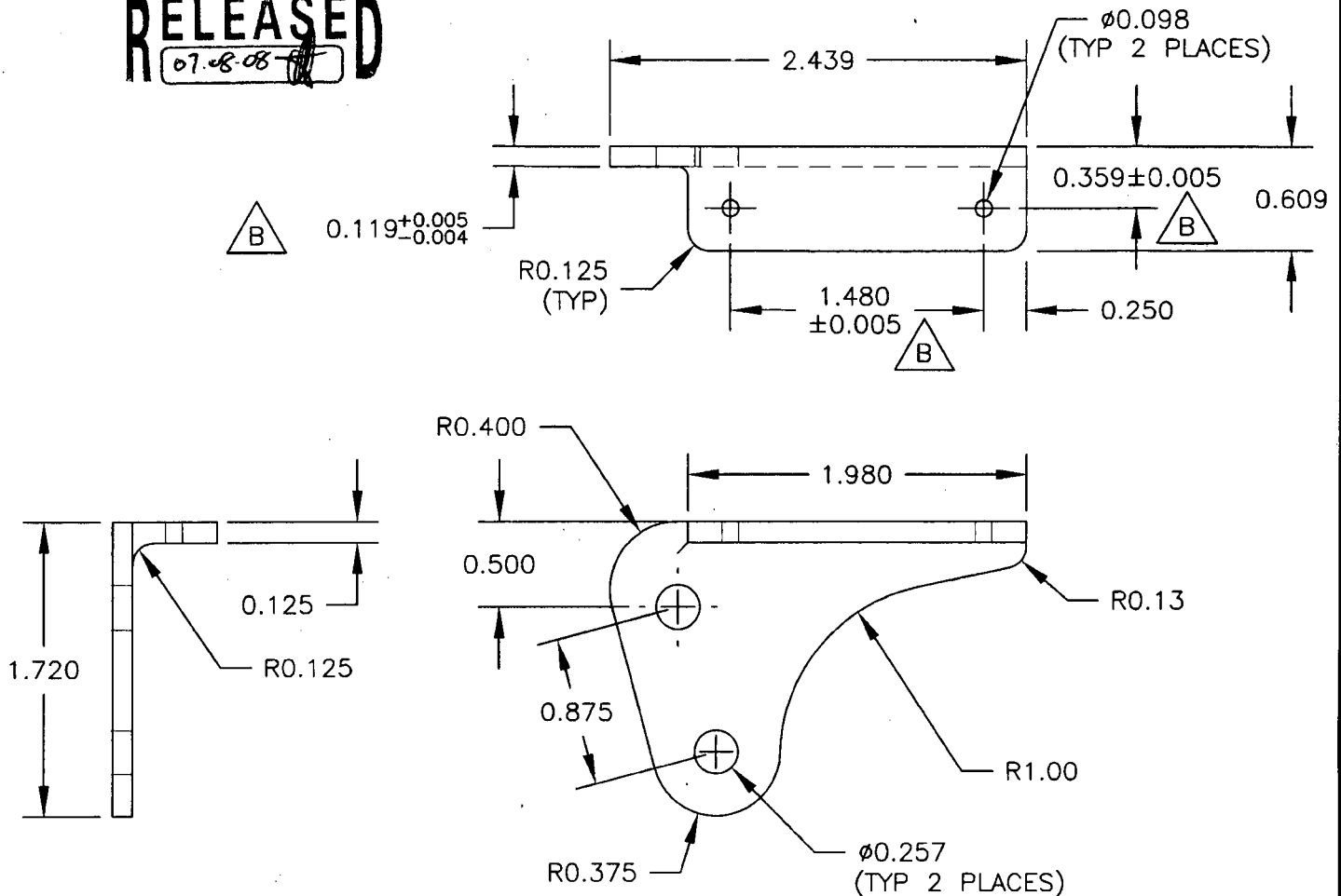
| Qty | Part Number | Description |
|-----|--------------|------------------|
| X | D3278-041 | SUPPORT ASSEMBLY |
| 2 | D2230-1 | CLAMP |
| 1 | D3278-1 | SUPPORT |
| 1 | D3278-2 | SUPPORT |
| 1 | D3278-3 | SPACER |
| 2 | AN4-13A | BOLT |
| 4 | AN960JD416 | WASHER |
| 4 | MS20426AD3-6 | RIVET |
| 2 | MS21042L4 | NUT |

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DART

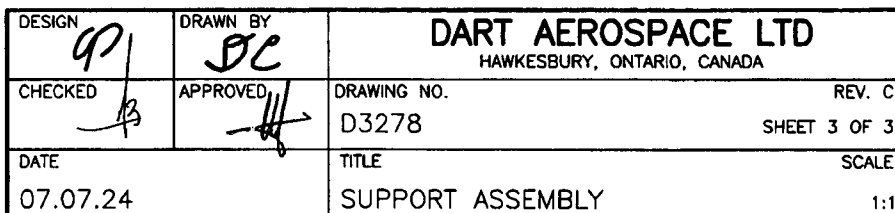
| | | | |
|---------------------|-----------------------|---|------------------------|
| DESIGN <i>9P</i> | DRAWN BY <i>BC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>B</i> | APPROVED <i>H</i> | DRAWING NO. D3278 | REV. C SHEET 2 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE 1:1 |

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

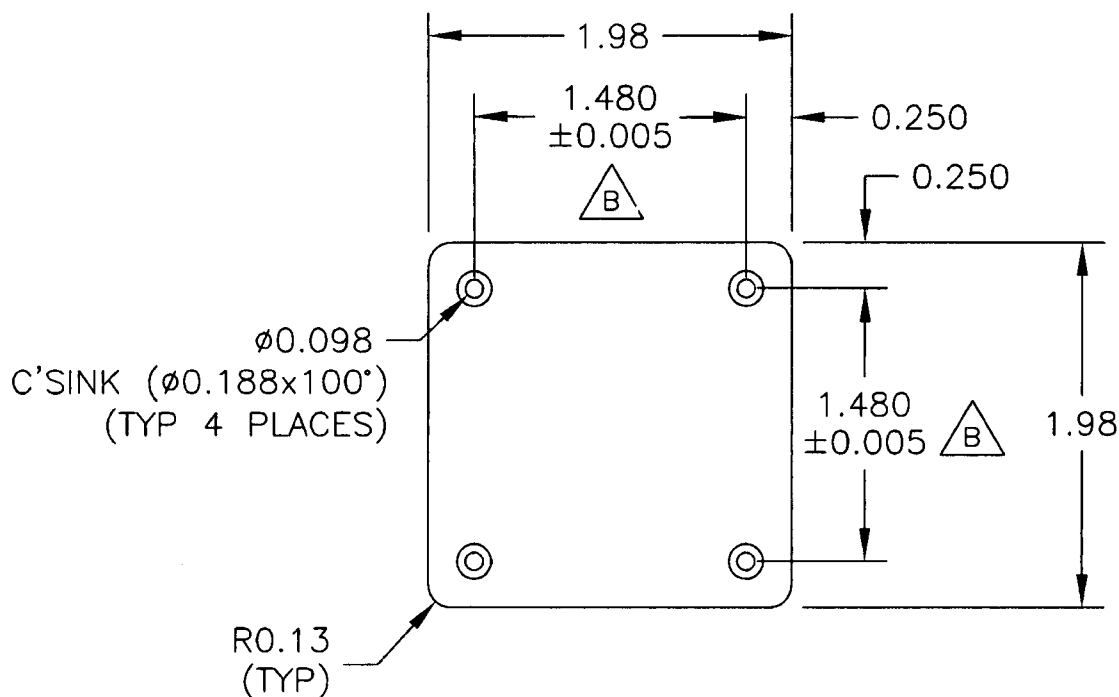
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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RELEASED
07.08.08



- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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